

Thursday, March 30, 2017 4:12:18 PM

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

40

Cust Item ID:

Start Date: 3/31/2017 **Start Qty:** 40.00

Required Date: 4/8/2017 **Req'd Qty:** 40.00

40

Customer:

Reference: SCHEDULED/S

Approvals:

Process Plan:

Date:

MAR 30 2017

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

100	HAAS CNC VERTICAL MACHINING #1	2.84	40	0	45 174-1 9-89
100					
HAAS 1	Memo	10.19			
HAAS CNC vertical machine #1	Program Batch No. 15874 Double check by: 1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets3-Machine Step No 3 per Folio FA641 and inspect p				
110	QC1- Inspection performed by CMM	0.00	40	0	DAS 45 174-1 9-89
110					
QC	Memo	0.40			
Quality Control	Inspect on CMM as per folio CMMA031. DWG REV: _____ CMM PROG. REV: _____				
120	QC8- Inspect parts - second check	0.00	40	0	DAS 44 15-04-0 9-89
120					
QC	Memo	0.80			
Quality Control					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
☐ Environment	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
☐ Design	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
☐ Doc/Data	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
☐ Equip/Tooling	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
☐ Handling/Pre	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
☐ Material	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
☐ Internal Transport	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
☐ Tribal Knowledge	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
☐ LOA	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
☐ Substation	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
☐ Past Expiry Date	☐ Manufacturing Process	OTHER : _____					
☐ Misidentified	☐ Past Due						

Work Order ID 158741

Thursday, March 30, 2017 4:12:18 PM

158741

Page 2

Item ID: D3500-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle
 Start Date: 3/31/2017 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 4/8/2017 Req'd Qty: 40.00 ***40*** Customer:
 Reference: SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130 HandFinish Hand Finishing	Memo	2.23				X40			201704/11 BEB.
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
140 Powdercoat Powder Coating	Memo START TIME: <u>10:50</u> FINISH TIME: <u>11:00</u>	1.23				40	φ	17-04-12.888	
150	QC3- Inspect Part Finish	0.00							
150 QC Quality Control	Memo	0.40				40			DAS 38 9-88 APR 12 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
		OTHER : _____							

Work Order ID 158741

Thursday, March 30, 2017 4:12:18 PM

158741

Page 3

Item ID: D3500-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle
Start Date: 3/31/2017 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 4/8/2017 Req'd Qty: 40.00 ***40*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location <u>5466</u>	0.00							
160									
Packaging	Memo	0.40				<u>240</u>	<u>8</u>	<u>APR 29 2017</u>	
Packaging							<u>3.00</u>		
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	4.00							<u>17/5/1</u> <u>JA</u>
Quality Control									

DAS
21
9-29

MAY 01 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Thursday, March 30, 2017 4:12:22 PM

Page 1

Work Order ID: 158741

158741

Parent Item: D3500-1

D3500-1

Parent Item Name: Saddle

Start Date: 3/31/2017

Required Date: 4/8/2017

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-013		Manufactured	No			100	Each	51.0000	1	40			

D6102-013

Saddle Billet

Location

Loc Qty

Loc Code

MAT046

51

147083

1

154454

10

155197

20

155444

20

1
10
20
9

DAS
45 17-4-1
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

DART AEROSPACE LTD				Work Order: 158791	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.483	0.490		0.487	0.487	0.487	0.487	0.487
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		0.375	0.375	0.375	0.375	0.375
F	0.490	0.510		0.500	0.500	0.500	0.500	0.500
H	R0.515	R0.535		0.525	0.525	0.525	0.525	0.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.582	1.580	1.582	1.579	1.583
J	0.240	0.260		0.252	0.252	0.252	0.254	0.253
K	0.490	0.510		0.500	0.499	0.500	0.500	0.500
L	3.590	3.650		3.62	3.62	3.62	3.62	3.62
M	0.315	0.322		0.317	0.317	0.317	0.317	0.317
N	0.256	0.262		0.259	0.259	0.259	0.259	0.259
O	6.500	6.520		6.508	6.508	6.508	6.508	6.508
P	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		0.546	0.546	0.543	0.546	0.543
V	0.793	0.803		0.798	0.798	0.798	0.798	0.798
W	R.240	R.260		0.250	0.250	0.250	0.250	0.250
X	0.040	0.060		0.050	0.050	0.050	0.050	0.050
Y	0.100	0.120		0.106	0.106	0.106	0.106	0.106
AA	R1.125	R1.145		1.140	1.135	1.137	1.135	1.136
AB	R.490	R.510		0.500	0.500	0.500	0.500	0.500
AC	0.615	0.635		0.625	0.625	0.625	0.625	0.625
AD	0.240	0.260		0.250	0.252	0.251	0.251	0.252
AE	1.810	1.830		1.823	1.822	1.822	1.822	1.822
AF	0.240	0.260		0.251	0.250	0.251	0.250	0.251
AG	0.140	0.160		0.152	0.151	0.151	0.150	0.151
AH	0.140	0.160		0.154	0.153	0.151	0.154	0.151
AI	0.140	0.160		0.154	0.156	0.155	0.156	0.157

DAS Accept/Reject

Measured by: 45 DAS	Date: 17-4-1
Audited by: 9-89 44	Date: 17-04-09
Preliminary Approval: 9-89	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order: 158741	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	27	18	19	10
A	0.483	0.490		0.487	0.487	0.487	0.487	0.487
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		0.375	0.375	0.375	0.375	0.375
F	0.490	0.510		0.500	0.500	0.500	0.500	0.500
H	R0.515	R0.535		0.525	0.525	0.525	0.525	0.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.582	1.586	1.586	1.584	1.585
J	0.240	0.260		0.252	0.252	0.252	0.252	0.251
K	0.490	0.510		0.500	0.500	0.500	0.500	0.500
L	3.590	3.650		3.62	3.62	3.62	3.62	3.62
M	0.315	0.322		0.317	0.317	0.317	0.317	0.317
N	0.256	0.262		0.259	0.259	0.259	0.259	0.259
O	6.500	6.520		6.508	6.508	6.508	6.508	6.508
P	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		0.543	0.546	0.544	0.543	0.545
V	0.793	0.803		0.798	0.798	0.798	0.798	0.798
W	R.240	R.260		0.250	0.250	0.250	0.250	0.250
X	0.040	0.060		0.050	0.050	0.050	0.050	0.050
Y	0.100	0.120		0.106	0.106	0.106	0.106	0.106
AA	R1.125	R1.145		1.136	1.139	1.136	1.136	1.136
AB	R.490	R.510		0.500	0.500	0.500	0.500	0.500
AC	0.615	0.635		0.625	0.625	0.625	0.625	0.625
AD	0.240	0.260		0.250	0.250	0.252	0.251	0.250
AE	1.810	1.830		1.822	1.823	1.823	1.8215	1.823
AF	0.240	0.260		0.250	0.252	0.251	0.250	0.250
AG	0.140	0.160		0.149	0.153	0.151	0.151	0.150
AH	0.140	0.160		0.154	0.154	0.154	0.154	0.154
AI	0.140	0.160		0.157	0.157	0.159	0.157	0.157

DAS Accept/Reject

Measured by: 45 DAS	Date: 17-4-2
Audited by: 44	Date:
Preliminary Approval: 9-89	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD		Work Order:	158741
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.483	0.490		0.487	0.487	0.487	0.487	0.487
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		0.375	0.375	0.375	0.375	0.375
F	0.490	0.510		0.500	0.500	0.500	0.500	0.500
H	R0.515	R0.535		0.525	0.525	0.525	0.525	0.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.584	1.584	1.586	1.586	1.583
J	0.240	0.260		0.254	0.254	0.251	0.252	0.251
K	0.490	0.510		0.500	0.500	0.495	0.499	0.499
L	3.590	3.650		3.62	3.62	3.62	3.62	3.62
M	0.315	0.322		0.317	0.317	0.317	0.317	0.317
N	0.256	0.262		0.259	0.259	0.259	0.259	0.259
O	6.500	6.520		6.508	6.508	6.508	6.507	6.507
P	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		0.545	0.545	0.549	0.545	0.543
V	0.793	0.803		0.798	0.798	0.798	0.798	0.798
W	R.240	R.260		0.250	0.250	0.250	0.250	0.250
X	0.040	0.060		0.050	0.050	0.050	0.050	0.050
Y	0.100	0.120		0.106	0.106	0.106	0.106	0.106
AA	R1.125	R1.145		1.135	1.136	1.136	1.136	1.136
AB	R.490	R.510		0.500	0.500	0.500	0.500	0.500
AC	0.615	0.635		0.625	0.625	0.625	0.625	0.625
AD	0.240	0.260		0.253	0.251	0.252	0.250	0.254
AE	1.810	1.830		1.820	1.819	1.821	1.821	1.820
AF	0.240	0.260		0.250	0.249	0.250	0.250	0.250
AG	0.140	0.160		0.150	0.149	0.150	0.150	0.150
AH	0.140	0.160		0.155	0.155	0.155	0.154	0.154
AI	0.140	0.160		0.157	0.158	0.156	0.159	0.158

DAS
45 Accept/Reject

Measured by:	9-89 DAS	Date:	2017-4-2
Audited by:	44	Date:	17-04-09
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order: 158791	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1C	217	318	419	520
A	0.483	0.490		0.487	0.487	0.487	0.487	0.487
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		0.375	0.375	0.375	0.375	0.375
F	0.490	0.510		0.500	0.500	0.500	0.500	0.500
H	R0.515	R0.535		0.525	0.525	0.525	0.525	0.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.583	1.580	1.583	1.584	1.584
J	0.240	0.260		0.252	0.252	0.253	0.250	0.253
K	0.490	0.510		0.499	0.499	0.499	0.500	0.500
L	3.590	3.650		3.62	3.62	3.62	3.62	3.62
M	0.315	0.322		0.317	0.317	0.317	0.317	0.317
N	0.256	0.262		0.259	0.259	0.259	0.259	0.259
O	6.500	6.520		6.508	6.508	6.508	6.508	6.508
P	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		0.544	0.546	0.544	0.543	0.545
V	0.793	0.803		0.798	0.798	0.798	0.798	0.798
W	R.240	R.260		0.250	0.250	0.250	0.250	0.250
X	0.040	0.060		0.050	0.050	0.050	0.050	0.050
Y	0.100	0.120		0.106	0.106	0.106	0.106	0.106
AA	R1.125	R1.145		1.135	1.138	1.135	1.137	1.135
AB	R.490	R.510		0.500	0.500	0.500	0.500	0.500
AC	0.615	0.635		0.625	0.625	0.625	0.625	0.625
AD	0.240	0.260		0.251	0.250	0.254	0.252	0.250
AE	1.810	1.830		1.819	1.829	1.818	1.822	1.820
AF	0.240	0.260		0.252	0.251	0.250	0.250	0.250
AG	0.140	0.160		0.150	0.150	0.150	0.150	0.150
AH	0.140	0.160		0.154	0.154	0.154	0.154	0.155
AI	0.140	0.160		0.158	0.158	0.158	0.158	0.158

DAS
45
Accept/Reject

Measured by: 0.80 DAS	Date: 2017-4-3
Audited by: 44	Date: 17-04-09
Preliminary Approval: 9-89	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order: 158741	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				21	22	23	24	25
A	0.483	0.490		0.487	0.487	0.487	0.487	0.487
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		0.375	0.375	0.375	0.375	0.375
F	0.490	0.510		0.500	0.500	0.500	0.500	0.500
H	R0.515	R0.535		0.525	0.525	0.525	0.525	0.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.576	1.576	1.576	1.576	1.577
J	0.240	0.260		0.250	0.251	0.253	0.251	0.253
K	0.490	0.510		0.500	0.500	0.504	0.5025	0.504
L	3.590	3.650		3.62	3.62	3.62	3.62	3.62
M	0.315	0.322		0.317	0.317	0.317	0.317	0.317
N	0.256	0.262		0.259	0.259	0.259	0.259	0.259
O	6.500	6.520		6.510	6.510	6.510	6.5095	6.510
P	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		0.544	0.544	0.5495	0.548	0.5475
V	0.793	0.803		0.798	0.798	0.798	0.798	0.798
W	R.240	R.260		0.250	0.250	0.250	0.250	0.250
X	0.040	0.060		0.050	0.050	0.050	0.050	0.050
Y	0.100	0.120		0.106	0.106	0.106	0.106	0.106
AA	R1.125	R1.145		1.136	1.136	1.135	1.135	1.135
AB	R.490	R.510		0.500	0.500	0.500	0.500	0.500
AC	0.615	0.635		0.625	0.625	0.625	0.625	0.625
AD	0.240	0.260		0.251	0.252	0.253	0.250	0.251
AE	1.810	1.830		1.822	1.822	1.822	1.822	1.823
AF	0.240	0.260		0.250	0.250	0.25	0.250	0.250
AG	0.140	0.160		0.150	0.150	0.156	0.156	0.151
AH	0.140	0.160		0.154	0.154	0.154	0.154	0.154
AI	0.140	0.160		0.158	0.158	0.157	0.158	0.157

Accept/Reject
45
DAS

Measured by: 9-89 DAS	Date: 17-4-3
Audited by: 44	Date: 17-04-09
Preliminary Approval: 9-89	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD		Work Order:	158791
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	226	227	228	229	230
A	0.483	0.490		0.487	0.487	0.487	0.487	0.487
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		0.375	0.375	0.375	0.375	0.375
F	0.490	0.510		0.500	0.500	0.500	0.500	0.500
H	R0.515	R0.535		0.525	0.525	0.525	0.525	0.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.585	1.585	1.585	1.585	1.585
J	0.240	0.260		0.253	0.254	0.251	0.253	0.251
K	0.490	0.510		0.504	0.501	0.504	0.504	0.503
L	3.590	3.650		3.62	3.62	3.62	3.62	3.62
M	0.315	0.322		0.317	0.317	0.317	0.317	0.317
N	0.256	0.262		0.259	0.259	0.259	0.259	0.259
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		0.547	0.546	0.548	0.548	0.546
V	0.793	0.803		0.798	0.798	0.798	0.798	0.798
W	R.240	R.260		0.250	0.250	0.250	0.250	0.250
X	0.040	0.060		0.050	0.050	0.050	0.050	0.050
Y	0.100	0.120		0.106	0.106	0.106	0.106	0.106
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		0.500	0.500	0.500	0.500	0.500
AC	0.615	0.635		0.625	0.625	0.625	0.625	0.625
AD	0.240	0.260		0.250	0.250	0.249	0.249	0.251
AE	1.810	1.830		1.825	1.823	1.822	1.821	1.820
AF	0.240	0.260		0.253	0.253	0.252	0.253	0.252
AG	0.140	0.160		0.154	0.152	0.152	0.153	0.154
AH	0.140	0.160		0.154	0.153	0.153	0.154	0.150
AI	0.140	0.160		0.153	0.154	0.154	0.154	0.155
Accept/Reject								

Measured by:	B. C. DAS	Date:	17-04-04
Audited by:	440	Date:	17-04-04
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order: 158791	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	31	32	33	34	35
A	0.483	0.490		0.487	0.487	0.487	0.487	0.487
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		0.375	0.375	0.375	0.375	0.375
F	0.490	0.510		0.500	0.500	0.500	0.500	0.500
H	R0.515	R0.535		0.525	0.525	0.525	0.525	0.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.582	1.585	1.580	1.581	1.583
J	0.240	0.260		0.253	0.252	0.252	0.253	0.252
K	0.490	0.510		0.504	0.504	0.504	0.503	0.504
L	3.590	3.650		3.62	3.62	3.62	3.62	3.62
M	0.315	0.322		0.317	0.317	0.317	0.317	0.317
N	0.256	0.262		0.259	0.259	0.259	0.259	0.259
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		0.548	0.545	0.5495	0.549	0.549
V	0.793	0.803		0.798	0.798	0.798	0.798	0.798
W	R.240	R.260		0.250	0.250	0.250	0.250	0.250
X	0.040	0.060		0.050	0.050	0.050	0.050	0.050
Y	0.100	0.120		0.106	0.106	0.106	0.106	0.106
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		0.500	0.500	0.500	0.500	0.500
AC	0.615	0.635		0.625	0.625	0.625	0.625	0.625
AD	0.240	0.260		0.248	0.250	0.250	0.250	0.250
AE	1.810	1.830		1.8215	1.822	1.824	1.822	1.822
AF	0.240	0.260		0.253	0.252	0.252	0.251	0.251
AG	0.140	0.160		0.152	0.153	0.152	0.151	0.151
AH	0.140	0.160		0.151	0.154	0.152	0.153	0.153
AI	0.140	0.160		0.154	0.154	0.154	0.154	0.154
Accept/Reject								

Measured by: DAS	Date: 17-04-05
Audited by: 44	Date: 17-04-09
Preliminary Approval: 9-89	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				136	237	338	439	540
A	0.483	0.490		0.487	0.487	0.487	0.487	0.487
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		0.375	0.375	0.375	0.375	0.375
F	0.490	0.510		0.500	0.500	0.500	0.500	0.500
H	R0.515	R0.535		0.525	0.525	0.525	0.525	0.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.580	1.582	1.582	1.582	1.582
J	0.240	0.260		0.253	0.253	0.253	0.253	0.253
K	0.490	0.510		0.503	0.504	0.504	0.504	0.504
L	3.590	3.650		3.62	3.62	3.62	3.62	3.62
M	0.315	0.322		0.317	0.317	0.317	0.317	0.317
N	0.256	0.262		0.259	0.259	0.259	0.259	0.259
O	6.500	6.520		6.509	6.510	6.510	6.510	6.510
P	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		0.548	0.548	0.548	0.548	0.548
V	0.793	0.803		0.798	0.798	0.798	0.798	0.798
W	R.240	R.260		0.250	0.250	0.250	0.250	0.250
X	0.040	0.060		0.050	0.050	0.050	0.050	0.050
Y	0.100	0.120		0.106	0.106	0.106	0.106	0.106
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		0.500	0.500	0.500	0.500	0.500
AC	0.615	0.635		0.625	0.625	0.625	0.625	0.625
AD	0.240	0.260		0.252	0.252	0.252	0.252	0.252
AE	1.810	1.830		1.821	1.822	1.822	1.822	1.821
AF	0.240	0.260		0.253	0.252	0.252	0.252	0.251
AG	0.140	0.160		0.152	0.152	0.150	0.150	0.150
AH	0.140	0.160		0.151	0.151	0.151	0.151	0.150
AI	0.140	0.160		0.154	0.153	0.153	0.153	0.153

Accept/Reject

Measured by: <u>BAE</u>	Date: <u>17-04-05</u>
Audited by: <u>44</u>	Date: <u>17-04-09</u>
Preliminary Approval: <u>3-89</u>	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

